124143

Page 1

| September-11-14 1 | 1:56:03 AM | | SWITE STATE | VAO AC AU (0 845) | | | | | |
|--------------------------------|--|---------------------------|------------------------|--------------------------------|---------------------|---------------|---------------|------------------|-------------------|
| Revision ID: Item Name: Bl | 3488-042 ade Fitting RH 10/14 Start Qty: 8.00 10/14 Req'd Qty: 8.00 | *8* *8* | Accept | *N900 Cust Iten Customer | | Λ* · | Setup Sta | *N | S1* S2* |
| | Process Plan: MCJ | Date: 14-09-12 | Tooling: SPC (Y/N): | Ta . | Date: | F | Run Sta | ^[V] | R1* |
| Sequence ID/ Work Center ID | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| Draw Nbr | Revision Nbr | | dic. | | | | | | |
| D3488 DSK 101 | Rev B REV D | | | | | | | | |
| 100 *100* Doosan Lathe | DOOSAN LATHE Memo 1-Turn as p | er Dwg DSK 101 & Folio F/ | | DAS 40 9-89 | 7 | 8 | , Ø | | DAS 25 9-89 |
| 110 *110* QC Quality Control | 2-Deburr QC2- Inspect parts off r Memo | nachine FAI/FAIB | 0.00 | DAS 40 9-89 | 7 | 8 | Ø | | DAS 25 9-89 |

| DQA: | | _ Date: | | | | | | | | | | DART |
|----------------------|--|--------------|--------|----------------------|-----------------------------------|------|--|--|----|--|--|--------------------|
| QA Closed: | | Date: | | | WORK ORDER NON- | -C(| ONFO | RMANCE / UPDATE | W | ork Order up | ndate only | AEROSPACE |
| QA Closed. | | Date. | | | | | | | | | | |
| Work Orde | r: | | | | DISPOSITION | | | AGAINSI | DE | PARTMENT, | _ | |
| | | | | | Rework | | | Skid-tube Crosstube | - | | Water Jet | Engineering |
| Part N | 0 | | | | Scrap | | | Machining Small Fab | _ | | d. Eng. Coor. | Quality |
| NCD N | | | | | Use-as-is Suspected Unapproved | | Therr | noforming Finishing Large Fab Composite | | Rec/Stor | re/Packaging Supplier | Other |
| NCR N | 0 | | | x | Suspected Onapproved | 1 | | Large Pab Composite | _ | 1 | Supplier_ | |
| Root | | | | Desci | ription of work order update | | nitial | Action | | Sign & | | |
| Cause | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Description | | Date | Verification | QC Inspector |
| Design | _ | | | | | | | | | | | |
| Doc/Data | _ | | | | | | | | | | | |
| Equip/Tooling | _ | | | | | | | | | | | |
| Handling/Pre | - | | | | | | | | | | | |
| Material Operator | - | | | | | | | | | | | |
| Offset/Setup | - | | | | | | | | | | | |
| Process | | | | | | | 3.0 | | | | | |
| Supplier - 1 | | | | | | | W | | | | | |
| Training | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | |
| 240 | | | | | | FAI | ULT CA | TEGORY | | | | |
| Landin | g Gear | | | | General | 8 | ALC: | | | 1 | _ | |
| 684 | Bendin | 3 | | | Bend | | Folio/F | Program | | Outside Dim | | Pressure/Forced |
| | Centre | Not Conce | ntric | | BOM/Route | | Grain | | | Over/Under | | Set-up |
| | Cracks | | | | Broken/Damage/Defect | 21 | Hardwa | All the second s | | Part Incorred | <u> </u> | Temperature/Cure |
| | Crimp/ | Kink/Ripple | e/Wave | - | Burrs | | 1 50 75 | ion Incomplete/Unqualified | | Part Lost/Mi | ssing | Weld |
| | Cuffs | | | | Contamination | 3,13 | A CONTRACTOR | tions Incomplete/Unclear | ag | Part Moved | L | Wrong Stock Pulled |
| | Crushin | | | . 1 | Countersink | | The same of the sa | gned/off center | | Positioned V | | Tarr |
| 4 | Heat Tr | | descri | | Cut Too Short | | Mislabe | | | Power Loss/ | Surge | Other |
| | The second secon | ion Strip in | Tube | 1 | Drawing | | Misread | STATE OF THE STATE | | | | A |
| - 4 | 3 2 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 | Chatter | Page 1 | | Drill Holes | 10 | Off-set | | | | | |
| 1733 | (C) H | Sequence | | | Finish Fit/Function | 1000 | PERSONAL PROPERTY. | Calibration | | 1000 | Control of the contro | |
| Transaction of | I Wave/ | WIST ID THE | Die . | CHARLES THE PARTY OF | TELL/EHIGHOH | 100 | HARLE OF | PERMENCE | | AND THE PERSON OF THE PERSON O | | |

Work Order ID 124143

124143

Page 2

September-11-14 11:56:03 AM Accept Item ID: D3488-042 *N900040100* Setup Start Revision ID: Stop Item Name: Blade Fitting RH Start Date: Start Qty: 8.00 *8* 9/10/14 Cust Item ID: Required Date: 9/10/14 Req'd Qty: 8.00 *2* **Customer:** Reference: Start Run Process Plan: Approvals: Date: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Tool# Operation Set Up/ Tool ID Plan Accept Reject Reject Insp. **Work Center ID** Description Run Hours Code Qty Qty Number Stamp 120 0.00 HAAS CNC VERTICAL MACHINING #1 *120* HAAS 1 0.00 Memo HAAS CNC vertical machine #1 1-Machine as per Folio FA627 & Dwg D34882-Deburr 130 QC2- Inspect parts off machine FAI/FAIB 0.00 *130* QC 0.00 Memo Quality Control DA 140 QC8- Inspect parts - second check 0.00 05 *140* 9-B QC 0.00 Memo Quality Control

| DQA: | | | Date: | | | | | | | | | | DART |
|---------------|---------|-----------------------|----------|---------|-----------|--|-----|--|--|----|-------------------|---------------|--|
| | | | | | | WORK ORDER NON- | -CC | ONFO | RMANCE / UPDATE | | | | AEROSPACE |
| QA Closed: | | | Date: | | | | | | | W | ork Order up | date only | |
| Work Orde | er: | | | | | DISPOSITION | | | AGAINST | DE | PARTMENT | PROCESS | |
| | | | | | _ | Rework | | | Skid-tube Crosstube | | | Water Jet | Engineering |
| Part N | lo. | | | | | Scrap | | 1 | Machining Small Fab | | Pro | d. Eng. Coor. | Quality |
| | and the | | | | - 10 | Use-as-is | | Therr | noforming Finishing | | Rec/Stor | e/Packaging | Other |
| NCR I | ١٥. | | | | _ | Suspected Unapproved | | | Large Fab Composite | | | Supplier | |
| Root | | - | | | Desci | ription of work order update | - 1 | nitial | Action | | Sign & | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Description | | Date | Verification | QC Inspector |
| Design | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | | |
| Unapproved | | | | | L | | | U T CA | TECODY | _ | | | |
| | | | | _ | | | FAU | JLI CA | TEGORY | _ | | | |
| Landi | | l | | | | General | | F-11- /F | | | Outside Dim | oneione - | Pressure/Forced |
| | | Bending | | 41141 | - | Bend Bott/Boute | H | | Program | - | Over/Under | | Set-up |
| 3.3 | - | Centre No | t Concer | itric | | BOM/Route | | Grain | | H | Part Incorrec | | Temperature/Cure |
| Ball | _ | Cracks | I- /p!I- | NA town | - | Broken/Damage/Defect | | Hardwa | ion Incomplete/Unqualified | | Part Lost/Mi | | Weld |
| | | Crimp/Kin | к/кірріе | wave | - | Burrs | | 100 | | H | Part Moved | | Wrong Stock Pulled |
| | | Cuffs | | | - | Contamination Countersink | - | | tions Incomplete/Unclear gned/off center | | Positioned W | | in one stock rulled |
| | | Crushing Heat Trea | | | - | Cut Too Short | | Mislabe | The state of the s | | Power Loss/s | 1000 | Other |
| | | Inspection | | Tubo | | Drawing | _ | Misrea | | | J. C. CO33/ | | 一种 |
| | 100 | Marks/Ch | | rube | - 1 | Drill Holes | | Off-set | | | | V. (4) | |
| | 15 | Turning Se | | | 33 | Finish | 100 | 1 3 to 2 to 2 to 3 to 3 to 3 to 3 to 3 to | Calibration | | Charles St. Carlo | CALL CONTRACT | |
| | | Wave/Twi | | P | 1 1 2 3 | Fit/Function | 100 | 200 | Sequence | | - 100 pt | | W S Facilities |
| 100 | 6.83 | Real Property lies | 100 | 200 | James Co. | COMPANY TO THE REAL PROPERTY OF THE PARTY OF | 1 | The state of the s | | | | | The same of the sa |

Work Order ID 124143

Quality Control

124143

Page 3

September-11-14 11:56:03 AM Accept Item ID: D3488-042 Setup Start *N900040100* Revision ID: Stop Item Name: Blade Fitting RH *8* Start Date: 9/10/14 Start Qty: 8.00 Cust Item ID: Required Date: 9/10/14 Req'd Qty: 8.00 *8* Customer: Reference: Start Run Approvals: Process Plan: Date: Tooling: Date: Stop OC: SPC (Y/N): Date: Date: Sequence ID/ Tool ID Plan Reject Operation Set Up/ Tool # Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 150 Chemical Conversion Coat per QSI005 4.1 0.00 *150* HandFinish 0.00 Memo Hand Finishing 160 White Gloss(Ref:4,3,5,1) per QSI005 4,3-Alum 0.00 7 0 14-11-17. 848.6 *160* Powdercoat 0.00 Memo Powder Coating OVEN TEMPERATURE: 170 QC3- Inspect Part Finish 0.00 X FRH & M *170* QC 0.00 Memo

DAS 15 9-89

| DQA: | | | Date: | | | WORK ORDER NON | cc | MEOI | DMANICE / LIDDATE | | | | DART |
|---------------|-------|------------|-----------|--------|---|------------------------------|-------|-----------|----------------------------|------|---------------|---------------|--------------------|
| QA Closed: | | | Date: | | | WORK ORDER NON | -00 | JINFOI | | Wo | ork Order up | date only | AEROSPACE |
| Work Orde | | | | | | DISPOSITION | | | AGAINST | DE | PARTMENT, | /PROCESS | |
| Work Orde | - | | | | | Rework | 1 | | Skid-tube Crosstube | | | Water Jet | Engineering |
| Part N | Jo. | | | | | Scrap | | 1 | Machining Small Fab | - | Pro | d. Eng. Coor. | Quality |
| 1 01 01 | | | | | - 1 | Use-as-is | | | noforming Finishing | | | e/Packaging | Other |
| NCR N | No. | | | | | Suspected Unapproved | | | Large Fab Composite | = | | Supplier | |
| | | | | N. | | | | | | | | | |
| Root | | | | 200 | Descr | ription of work order update | | nitial | Action | | Sign & | | |
| Cause | _ | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Description | | Date | Verification | QC Inspector |
| Design | | | | | | | | | | | | | |
| Doc/Data | | | 1 | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | |
| Handling/Pre | _ | | | | | | | | | | | | |
| Material | _ | | | | | | | | | | | | |
| Operator | _ | | | | | | | | | | | | |
| Offset/Setup | _ | | | | | | | | | | | | |
| Process | - | | | | | | | | | | | | |
| Supplier | - | | | | | | | | | | | | |
| Training | - | | | | | | | | | | = | | 2 |
| Transport | - | | | 11.1 | | | | | | | | | 1.77 |
| Unapproved | | | | | - | | FAI | III T CAT | TEGORY | _ | | | |
| Landir | ng Ge | ear | | | | General | | 021 071 | | | | | |
| | | Bending | | | | Bend | | Folio/P | rogram | | Outside Dim | ensions | Pressure/Forced |
| ici | | Centre No | t Concer | ntric | | BOM/Route | | Grain | | | Over/Under | tolerance | Set-up |
| î | | Cracks | | | | Broken/Damage/Defect | | Hardwa | nre | | Part Incorrec | it 🗔 | Temperature/Cure |
| HB. | | Crimp/Kin | k/Ripple | /Wave | | Burrs | - 604 | Inspect | ion Incomplete/Unqualified | | Part Lost/Mi | ssing | Weld |
| | | Cuffs | | P. III | | Contamination | | | tions Incomplete/Unclear | | Part Moved | | Wrong Stock Pulled |
| | | Crushing | | | 7619 | Countersink | | 1 | ned/off center | | Positioned V | /rong | |
| | - | Heat Trea | ŧ. | | 700 | Cut Too Short | | Mislabe | | | Power Loss/ | Surge | Other |
| 1 - 1 | - | nspection | | Tube | | Drawing | | Misread | 1 | e in | 2 True 15 | 1 2 | 4 |
| 100 | | Marks/Ch | | | CL. | Drill Holes | 500 | Off-set | | | as agreed to | A 175 | My A |
| | | Turning Se | | Time. | 62: | Finish | | Out of | Calibration | 9.00 | - Markey | C 4.75.00 | |
| -1-20 | 200 | Mayo/Twi | et in Tub | 0 | F 19 10 10 10 10 10 10 10 10 10 10 10 10 10 | Fit/Function | | Out of | Sequence | 1954 | E STATE | THE WAR OF | |

Work Order ID 124143

Packaging

124143

Page 4

September-11-14 11:56:03 AM Accept Item ID: D3488-042 *N900040100* Setup Start Revision ID: Item Name: Blade Fitting RH *8* Start Date: Start Qty: 8.00 9/10/14 Cust Item ID: Required Date: 9/10/14 Req'd Qty: 8.00 *0* **Customer:** Reference: Start Run Process Plan: Approvals: Date: Tooling: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Accept Reject Reject Insp. Work Center ID Description Run Hours Code Qty Qty Number Stamp 180 0.00 HandFinishing *120* HandFinish 0.00 Memo Hand Finishing Install Inserts as per Dwg D3488 190 QC5- Inspect part completeness to step on W/O 0.00 7 0 14-11-17 858 *190* QC 0.00 Memo Quality Control Identify as per dwg & Stock Location: 200 0.00 7 13H of Ill whele *200* Packaging 0.00 Memo

| DQA: | | | Date: | | | WORK ORDER NON | - | 201501 | DAMANCE / LIDDATE | | | | DART | | |
|---------------|--|----------------|-----------------------------|-------|-------|--------------------------------|-----|---------|---|----------|--|-------------------------------|--------------------|--|--|
| QA Closed: | | | Date: | | | WORK ORDER NON- | -((| JNFOI | RIMANCE / UPDATE | W | ork Order up | date only | AEROSPACE | | |
| | _ | | | | | DISPOSITION | | | AGAINST | DE | PARTMENT | /PROCESS | | | |
| Work Ord | er: | | | | _ | _ | | | | _ | 1 | | | | |
| | | | | | | Rework | | | Skid-tube Crosstube | \vdash | | Water Jet | Engineering | | |
| Part I | ١٥. | | | | | Scrap | | | Machining Small Fab noforming Finishing | | | d. Eng. Coor. re/Packaging | Quality Other | | |
| NCR I | lo. | | | | | Use-as-is Suspected Unapproved | | Thern | noforming Finishing Large Fab Composite | - | Nec/stor | Supplier | Other | | |
| INCN | VO. | | | | _ | Suspected Onapproved | 1 | | composite | _ | J | Supplie! | | | |
| Root | | | | | Desci | ription of work order update | 1 | nitial | Action | | Sign & | | | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Description | | Date | Verification | QC Inspector | | |
| Design | | | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | |
| Offset/Setup | _ | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training | _ | | | | | | | | | | | | | | |
| Transport | _ | | | 34 | | | | | | | | | | | |
| Unapproved | Щ | | | | | | EAL | HT CAT | TEGORY | | | | | | |
| Landi | na (| Soar | | - | | General | FAI | OLI CA | IEGORI | | | | | | |
| Lanui | - | Bending | | | | Bend | | Folio/F | Program | | Outside Dim | ensions | Pressure/Forced | | |
| | | Centre No | t Concer | ntric | | BOM/Route | | Grain | | | Over/Under | - Contraction | Set-up | | |
| | | Cracks | | | | Broken/Damage/Defect | | Hardwa | ire | | Part Incorrec | | Temperature/Cure | | |
| | _ | COOK WHOCH WAS | rimp/Kink/Ripple/Wave Burrs | | | | | | ion Incomplete/Unqualified | | Part Lost/Mi | ssing | Weld | | |
| | Cuffs Contamination | | | | | | | N 00 | tions Incomplete/Unclear | 11 | Part Moved | | Wrong Stock Pulled | | |
| | 1 | Crushing | | | | Countersink | | 4 | gned/off center | | Positioned W | /rong | 2 01 | | |
| v | 1 | Heat Trea | t | | | Cut Too Short | _ | Mislabe | Take the second | | Power Loss/S | Surge | Other | | |
| | _ | Inspection | | Tube | | Drawing | -33 | Misread | d | | | | 7.1 | | |
| | _ | Marks/Ch | | | - 1 | Drill Holes | 8 | Off-set | | | | | | | |
| 1 | | Turning Se | equence | | . 2 | Finish | | Out of | Calibration | | THE RESERVE OF THE PARTY OF THE | | | | |
| | Turning Sequence Finish Wave/Twist in Tube Fit/Function | | | | | | | Out of | Sequence | | W. III J. 77(59) | Carlotte de la care | | | |

| V | W. | 21 | 0 | nd. | or | ID | 1 | 24 | 1/12 | |
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| V | V 4 | | w a | | er | 111 | | 44 | 14.7 | į. |

124143

Page 5

| September-11 | -14 11:56:03 | AM | | 1/2 | + 14.7 | | | | | | | |
|--------------------------------|--------------|--------------------------|--------------------|----------------------|-------------|-------|--------------|--------------|--------------|-------|------------------|----------------|
| Item ID: Revision ID: | D3488-04 | 2 | | Accept | *N900 | 040 | 100 |)* | Setup | Start | *N! | S1* |
| Item Name: | Blade Fittin | g RH | | | | | | | | Stop | *N. | S2* |
| Start Date: | 9/10/14 | Start Qty: 8.00 | *8* | | Cust Item I | D: | | | | | 10: 606 | 5956 |
| Required Dat | e: 9/10/14 | Req'd Qty: 8.00 | *8* | | Customer: | | | | | | | |
| Reference: | | | | | | | | | | | | |
| Approvals: | Process I | Plan: | Date: | Tooling: | Da | ate: | | | Run | Start | ~1/J1 | R1* |
| | QC: | | Date: | SPC (Y/N): | D: | ate: | | | | Stop | *NI | R2* |
| Sequence ID/ Work Center | ID | Operation Description | | Set Up/ Run Hours | Tool ID | Tool# | Plan Code | Accep Qty | t Rej Qty | | Reject Number | Insp. Stamp |
| 210 | | QC21- Final Inspection | Work Order Release | 0.00 | | | | | | | | ~)() |
| *210* QC Quality Control | | Memo | | 0.00 | | | | | | 14/ | 11/7 | 8 % |

John-11-17

| DQA: | | | Date: | | | | | | | | | | DART |
|---------------|-----|---------------------|------------|---------|--------|------------------------------|---------------|-------------------|----------------------------|----------|---------------------------------------|---------------|--------------------|
| | | | | | | WORK ORDER NON | -CC | ONFO | RMANCE / UPDATE | 14/ | auli Ondan iin | data anlu | AEROSPACE |
| QA Closed: | | | Date: | | | | _ | | | VV | ork Order up | date only | |
| Work Orde | er: | | | | | DISPOSITION | | | AGAINS | T DE | PARTMENT | /PROCESS | _ |
| | | | | | | Rework | | | Skid-tube Crosstube | 2 | | Water Jet | Engineering |
| Part N | 10. | | | | | Scrap | | | Machining Small Fal | _ | 71.00 NO.000 | d. Eng. Coor. | Quality |
| | | | | | | Use-as-is | | Thern | noforming Finishing | | Rec/Stor | re/Packaging | Other |
| NCR N | ١٥. | | | | _ | Suspected Unapproved | | | Large Fab Composite | | | Supplier | |
| Root | | | | | Desci | ription of work order update | | nitial | Action | | Sign & | | |
| Cause | | Date | Step | Qty | D 000. | or non-conformance | ~~~ | ief Eng | 400 00 000 | | Date | Verification | QC Inspector |
| Design | | | | | | | | | | | | | |
| Doc/Data | | | | ľ | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | |
| Transport | | 1 | | | | | | | | | | | |
| Unapproved | | | | | | | | | | _ | | | |
| | | | | _ | | | FAI | JLT CA | regory | | | | |
| Landi | | N | | | | General | | lealia/r | rogram | | Outside Dim | onsions | Pressure/Forced |
| | | Bending | + C | . dulla | | Bend BOM/Route | H | Grain | Togram | - | Over/Under | | Set-up |
| | | Centre No Cracks | it Concer | TEFIC | | Broken/Damage/Defect | H | Hardwa | IFO. | \vdash | Part Incorrec | | Temperature/Cure |
| | - | Crimp/Kin | √/Dinnlo | AMayo | - | Burrs | H | | ion Incomplete/Unqualified | - | Part Lost/Mi | | Weld |
| | | Cuffs | M Wibbie | / wave | | Contamination | $\overline{}$ | | tions Incomplete/Unclear | H | Part Moved | | Wrong Stock Pulled |
| | | Crushing | | | | Countersink | | | ned/off center | | Positioned W | | 1 |
| 0,50 | | Heat Trea | t | | 1 | Cut Too Short | | Mislabe | | | Power Loss/S | | Other |
| 300 | 5 | Inspection | | Tube | | Drawing | 115 | Misread | | _ | days is 11 and | | |
| 100 | | Marks/Ch | | | | Drill Holes | - | Off-set | | | the treet | H To G | |
| 9 8000 | 1 | Turning Se | | | | Finish | ine il | | Calibration | | 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 | | |
| 100 | 87 | | ict in Tub | 10 | - 7 | Eit/Eunction | 1003 | The second second | Seguence | | MA | | |

Picklist Print

September-11-14 11:56:03 AM

Work Order ID: 124143

124143

Parent Item:

D3488-042

D3488-042

Parent Item Name: Blade Fitting RH

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A New Issue 06-02-28 JLM

IPP Rev:B As per Rev B 06-03-30 JLM

IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Manufactured

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| ALS7-1032-225 | AELS8-1032-225 | Purchased | No | | | | Each | 544.0000 | | 32 - 2 | 8 | v v | |
| *AI \$7-103 | 32-225* | 1 | | | | | | | ** | لل | 1 14 | (i.) | (Z |

| Location | Loc Qty | Loc Code | |
|----------|---------|----------|-------------|
| FG | 80 | | |
| 118520 | 80 | 136565 | X28 |
| FP001 | 391 | | |
| m128649 | 391 | | |
| ST280 | 73 | | |
| m128179 | 73 | | <u>1</u> |
| | Each | 32.0000 | 8 |
| | | ** | SL 14-10-11 |

D6103-003

Round Billet, Aluminum

D6103-003

| - |
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| |

| DQA: | WORK ORDER NON-CONFORMANCE / UPDATE | | | | | | | | | | | | 7 | DART | |
|---------------|--|-----------|-----------|--------|----------|------------------------------|-------|---|----------------------------|------|---------------|---|---|--------------------|--|
| OA Classic | | | Date | | | WORK ORDER NON- | -CC | ONFOR | RMANCE / UPDATE | W | ork Order ur | ndate only | 7 | AEROSPACE | |
| QA Closed: | _ | | Date: | | _ | | _ | | | *** | ork Order up | date only | _ | | |
| Work Orde | er: | | | | | DISPOSITION | | | AGAINS | T DE | PARTMENT | /PROCESS | _ | | |
| | | | | | | Rework | | | Skid-tube Crosstub | | | *************************************** | _ | Engineering | |
| Part N | ١٥. | | | | | Scrap | | | Machining Small Fa | | | | _ | Quality | |
| | | | | | | Use-as-is | | 100000000000000000000000000000000000000 | noforming Finishin | 17.0 | Rec/Stor | | _ | Other | |
| NCR 1 | 10. | | | | - | Suspected Unapproved | | | Large Fab Composit | e | | Supplier | | | |
| Root | | | | | Desc | ription of work order update | | nitial | Action | | Sign & | | | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Description | | Date | Verification | 1 | QC Inspector | |
| Design | | | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | |
| Offset/Setup | tup | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | |
| Transport | _ | | | | | | | | | | | | | | |
| Unapproved | | | | | | | EAL | III CAT | TEGORY | - | | | _ | | |
| t marali | | | | | | General | FA | OLI CAI | EGORT | | | | | | |
| Landi | | Bending | | | | Bend | | Folio/P | rogram | | Outside Dim | ensions [| P | ressure/Forced | |
| | | Centre No | t Concen | tric | \vdash | BOM/Route | | Grain | 108.011 | | | | _ | | |
| | - | | it concer | itira. | - | Broken/Damage/Defect | | Hardwa | re | | Part Incorrec | | | | |
| | Cracks Broken/Damage/Defect Crimp/Kink/Ripple/Wave Burrs | | | | | | | DATE OF THE PARTY | ion Incomplete/Unqualified | | | 1 | _ | A | |
| | Cuffs Contamination | | | | | | | | ions Incomplete/Unclear | | Part Moved | | | Vrong Stock Pulled | |
| -31 | Crushing Countersink | | | | | | | 4 | ned/off center | | | Vrong | _ | | |
| # The 1 | IST. | Heat Trea | t | | 100 | Cut Too Short | - | Mislabe | | | | | 0 | ther | |
| E Line | Inspection Strip in Tube Drawing | | | | | | 100 | Misread | | _ | 2 4-1 | £ 334 | | | |
| - In-6 | Marks/Chatter Drill Holes | | | | | | 155 | Off-set | - Carlo | - 36 | 1975 | | | | |
| 100 | 417 | | | | 11 1 | Finish | 10/18 | Land Control | Calibration | | | er/Under tolerance Set-up t Incorrect Temperature/Cu t Lost/Missing Weld t Moved Wrong Stock Pul sitioned Wrong | | | |
| M. Com | Turning Sequence Finish Wave/Twist in Tube Fit/Function | | | | | | | Out of S | Sequence | | E. 文. 自. 图 · | Prod. Eng. Coor. Rec/Store/Packaging Supplier Sign & Verification QC Attside Dimensions Pressurer/Under tolerance rt Incorrect rt Lost/Missing rt Moved sitioned Wrong | | | |

| DART AEROSPACE LTD | Work Order: | 124143 |
|--|--------------|-------------|
| Description: Blade Fitting, RH / Turning Detail for D3488-1/-2 | Part Number: | D3488-2 |
| Inspection Dwg: D3488 / DSK101 Rev: B / D | | Page 1 of 2 |

FIRST ARTICLE INSPECTION CHECKLIST

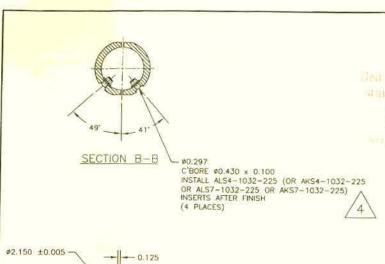
X First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|--------------------|------------------|------------|--------|-------------------------|----------------|
| | | Lath | ne Section | | | |
| Ø2.150 | +/-0.005 | 2 149 | | | Mic | Pan ay |
| Ø2.780 | +/-0.005 | 2.780 | | | Mic | Prb-04 |
| Ø3.125 | +/-0.010 | 3,123 | / | | VERN | PHO-12 |
| Ø3.346 | +/-0.010 | 3 346 | | | Vein | X-10 |
| 0.125 x 45° | +/-0.010 x +/-0.1° | .125 | | | n d | P+10-12 |
| 8.000 | +0.030/-0.000 | 8,012 | 1 | | 12 | |
| 9.250 | +/-0.010 | 9,249 | | | 18 | (NC-02 |
| 0.188 | +/-0.010 | .189 | / | | 4 | PHD-12 |
| R0.032 | +/-0.010 | - 032 | V | | Rad G | 110-12 |
| R0.062 | +/-0.010 | .062 | V | | 11 | |
| Ø0.297 | +0.005/-0.001 | .300 | / | | VERN | DHD-12 |
| Ø0.430 | +/-0.010 | .434 | 1 | | " | 17-W-12 |
| 0.100 | +/-0.010 | .104 | 1 | | Li | 145 |
| 0.125 | +/-0.010 | 130 | 1 | | ÎN. | L ^o |
| 2.620 | +/-0.010 | 2.623 | | | 14. | C.V. DZ |
| 3.500 | +/-0.010 | 3 500 | | | 1.0 | CNC-02 |
| 1.005 | +/-0.010 | 1,005 | / | | As | N. |
| Ø0.484 | +0.005/-0.001 | .486 | / | | 18 | P-10-12 |
| 1.180 | +/-0.010 | 1,180 | | | 16 | 170-12 |
| 3.150 | +/-0.010 | 3,150 | | | 16 | n |
| 3.070 | +/-0.010 | 3 069 | / | | H-6. | 31006 |
| R0.063 | +/-0.010 | .063 | / | | fad 6 | 51000 |
| | | | | | | |

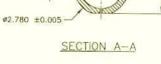
| DART AEROSPACE LTD | Work Order: | 124143 |
|--|--------------|-------------|
| Description: Blade Fitting, RH / Turning Detail for D3488-1/-2 | Part Number: | D3488-2 |
| Inspection Dwg: D3488 / DSK101 Rev: B / D | | Page 2 of 2 |

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|---------------|---------------------|------------|--------|-------------------------|----------|
| | | Milli | ng Section | 1 | | |
| Ø0.508 | +0.006/-0.001 | 508 | 0 | | gage Pi | ^ |
| 0.750 | +/-0.010 | 247 | ,/ | | Height | Sast |
| 1.500 | +/-0.010 | 1.497 | ~ | | Meght | Jase |
| 11.18 | +/-0.030 | 11/6 | 1 | | | |
| R0.062 | +/-0.010 | .062 | / | | Radius gar | |
| 0.125 | +/-0.010 | 125 | / | | Vern LP | 100 |
| 0.590 | +/-0.010 | 589 | 1 | | Height | Car D |
| 0.793 | +/-0.010 | .797 | ~ | | TICIGNT (| Jage |
| 1,351 | +/-0.010 | 1.352 | | | | |
| 1.317 | +/-0.010 | 1.310 | | | | |
| 1.802 | +/-0.010 | 1.802 | V | | 1 | |
| | | | | | | |
| | | | | | | |
| | 1.0 | | | 4 | | |

| | | DAS / | | | | | |
|------|----------|-----------------|-------------|----------|-----------------------|---------------------|--|
| Meas | ured by: | 40 / (1) | Audited by: | A. | DAS | Prototype Approval: | N/A |
| | Date: | 1/10/13/ /4/14 | Date: | 14/11/11 | 08 9-89 | Date: | N/A |
| Rev | Date | Change | | 1 1 | | Revised by | Approved |
| Α | 06.03.31 | New Issue | | | | KJ/JLM | E PER PER PER PER PER PER PER PER PER PE |
| В | 08.09.19 | Reformat | P/O D3488-0 | 42 | | K I/ II M | 1 |
| С | 08.12.02 | Dimension 8.000 | | | | KJ/JLM X | Gill |



2.620



D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

| QTY -041 | -042 | PART NUMBER | DESCRIPTION |
|-------------|------|---|-----------------------------|
| X | - | D3488-041 | BLADE FITTING ASSEMBLY (LH) |
| | X | D3488-042 | BLADE FITTING ASSEMBLY (RH) |
| 1 | | D3488-1 | BLADE FITTING (LH) |
| | 11 | D3488-2 | BLADE FITTING (RH) |
| 4 | 4 | ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225 | INSERT |

D3488-041/-042 BLADE FITTING

1) MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR

PER 00-A-225/9

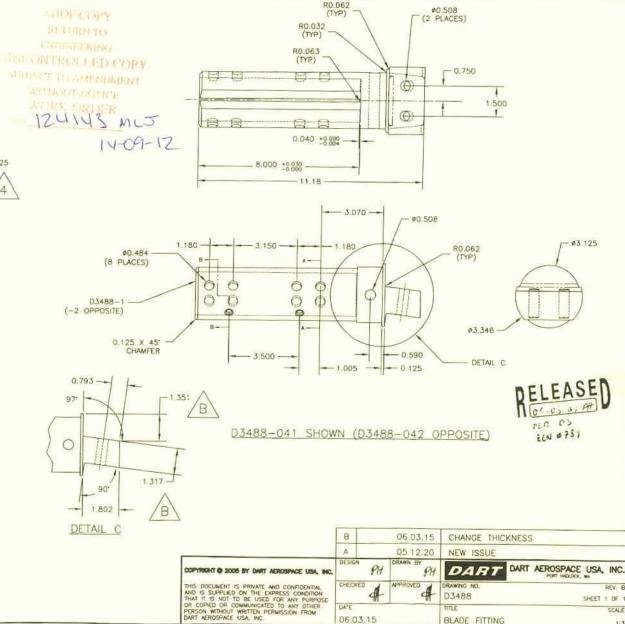
(REF. DART MATERIAL SPEC M7075T73R) ACID ETCH, ALODINE PER DART QSI 005 4.1

2) FINISH: POWDER COAT WHITE (REF 4.3.5.1) PER DART OSI 005 4.3

BREAK UNMARKED SHARP EDGES 0.010 TO 0.020

INSTALL INSERTS AFTER POWDER COAT ALL DIMENSIONS ARE IN INCHES 5)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DATE

06.03.15

D3488

BLADE FITTING

TITLE

SHEET 1 OF

SCALE

03-20-08-CV